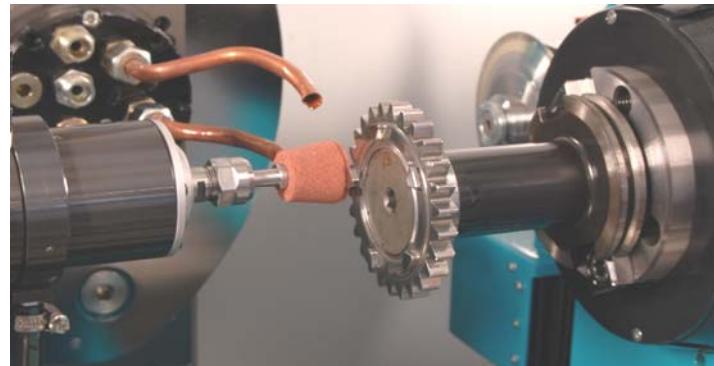


Cam grinding

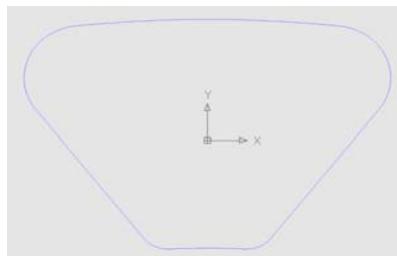
A20-200

This component is part of the gear box of a racing car. The polygonal positioning cam of the gear part is ground following a dxf profile. Dressing of the wheel is also done by dxf. Special high frequency motorspindel is needed for processing the part.



1. Cycletime for Production

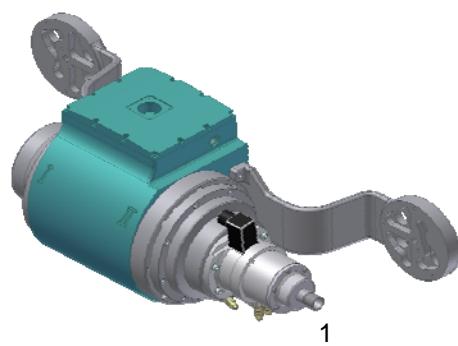
Specifications			
Diameter 130 mm, Z5			
Operations	Probe	Dress	Cam
Feed [mm/Min]	2000	150	5
Power [kW]		1	1
Cutting feed [m/s]		32	24
Used wheels			1
Grinding time [s]	20	120	450
Total cycle time	9 Min 50		



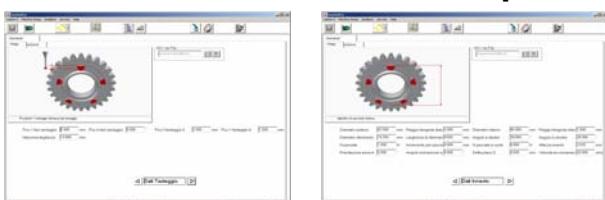
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø36 DXF Conventional



3. Machine and Software Requirements



Machines: 5 axes CNC grinders : NORMA CFG
Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5, DXQ

Engineer: Di, 01.04.2009

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